

Date: Friday, 5/25/2007 8:19:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-BOLT SPACER
Job Number : 32597	
Estimate Number : 12324	
P.O. Number : <u>N/A</u>	Part Number : D34905
This Issue : 5/25/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3490 REV A
Prsht Rev. : <u>NC</u>	Project Number : <u>N/A</u>
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : <u>A</u>
Previous Run : 29870	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 5/31/2007 Qty: 50 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev. A New Issue 06-03-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6T03125W058	ALUM. SEAMLESS TUBE
-----	-------------------	---------------------



Comment: Qty.: 0.2793 f(s)/Unit Total: 13.9650 f(s)
 6061-T6 Tube 500 x .049W — m6061T6T03125W058 cd.
 (M6061T6T0 500W.049)
 Batch: M104676

MS 07/06/11

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA630 & DWG D3490
 FOLIO REV: AA
 DWG REV: A

2-DEBURR AS REQUIRED

DJP 07/06/12 MS 07/06/11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 07/06/12 MS 07/06/11

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

D.F. 07/06/11

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1






Identify and Stock

Location: LC BE 07-06-12

154

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/12	2.0	61 parts vary from 0.001" to 0.003" under size, on A - 0.00" tolerance. Deviation caused by the tool offset	 QSI0412	Parts are acceptable.	 07-06-12	 07-06-12	 QSI0412	 0706.12

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:19:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 32597

Part Number: D34905

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



154

Comment: FINAL INSPECTION/W/O RELEASE

07/06/14

Job Completion



U 7.86.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

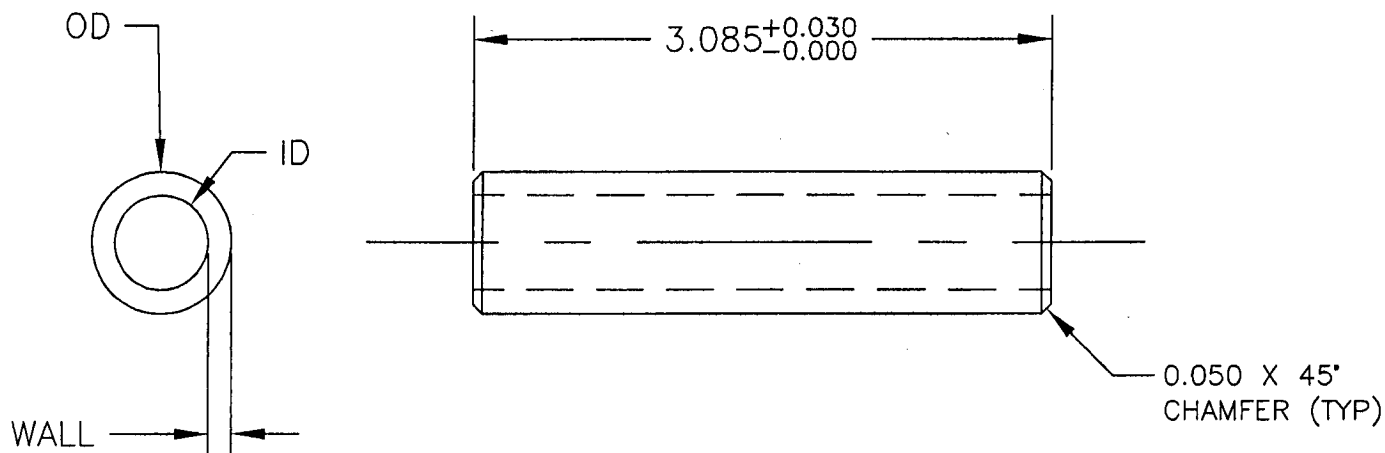
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	

**D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST**

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32597

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
do-02-07

Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

